

Date: Monday, 10/16/2006 2:02:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29025
Estimate Number : 10645
P.O. Number : N/A
This Issue : 10/16/2006 **S.O. No.** : N/A
Prsh Rev. : NC
First Issue : N/A **Type** : SMALL /MED FAB
Previous Run : 27523
Written By : *[Signature]*
Checked & Approved By : *[Signature]* 06 10 16
Comment : Est. D 02/03/06 Added note at step 7 NG
 Est Rev:E Now on Waterjet 06-06-13 JLM

Drawing Name : SPRING CLIP ASSEMBLY
Part Number : D2429041
Drawing Number : D2429 REV C1
Project Number : N/A
Drawing Revision : C1
Material : N/A
Due Date : 10/30/2006 **Qty:** 40 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		Comment: Qty.: 0.0071 sf(s)/Unit Total : 0.1428 sf(s) 304/316 .040 Sheet (M304S040) m1012641 Ml 06 12 01 Batch: m102159 Ml 06 10 18
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2429 Dwg Rev: C1 Prog Rev: C1
		<i>m1 06 12 01</i> (40)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>m1 06 12 01</i> (40)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<i>Jan 10 18 (20)</i> <i>Connted. NO6/12/01 (20)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		1-Deburr _____ <i>m1 06/10/05 (20)</i> SB 06/12/05 (20)
		2-Bend D2429-1 as per Dwg D2429
		<i>SB 06/11/05</i> (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/12/05	5.1	Add QCS to step 5.1 Perm. chg.	EZ	06.12.05	(HO)		AA 06/12/05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:02:59 PM
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Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 29025

Part Number: D2429041

Job Number:



Seq. #:	Machine Or Operation:	Description :	
6.0	MS20470AD45	Rivet, Universal Head	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Rivet, Universal Head	
		Pick: Qty Part number Description Batch	
		1 MS20470AD4-5 Rivet 118491	SB 06/12/06 (20)
7.0	AN960JD6L	Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Washer	
		Pick: Qty Part number Description Batch	
		2 AN960JD6L Washer MSS19	
		NOTE: 2 D2429-1 required for 1 assy.	SB 06/12/06 (20)
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: Assemble D2429-041 as per Dwg D2429	SB 06/12/06 (20)
9.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	06/12/06 (20)
10.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST45	06/12/06 (20)
11.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	06/12/06 (20)
		Job Completion	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

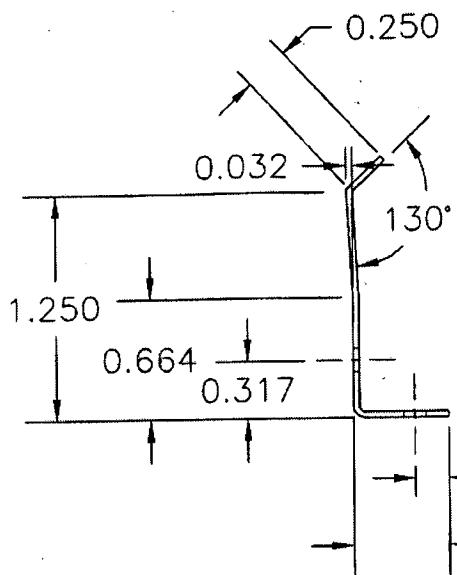
NOTE: Date & initial all entries

DART

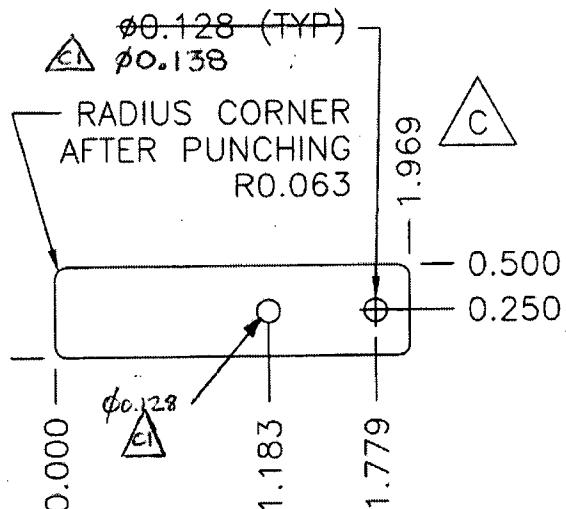
© COPY IS SUB
DRAFT

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26		TITLE SPRING CLIP	SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	01.03.27	$\phi 0.138$ WAS $\phi 0.128$	

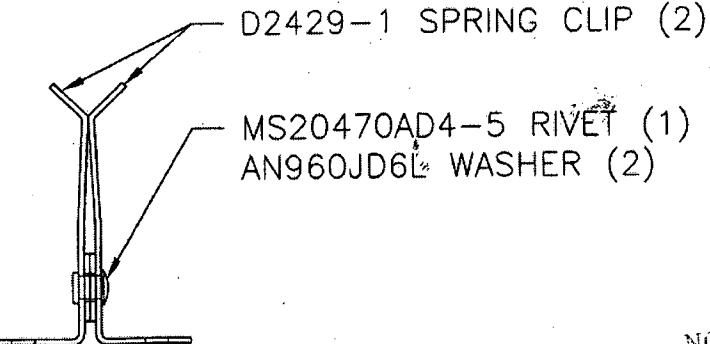
RELEASED
00.06.27 *#*



D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN



D2429-041 SPRING CLIP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
29025

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>J. M</u>	Prototype Approval:	
Date:	<u>06/10/18</u>	Date:	<u>06-10-18</u>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	